

Work Order ID 110168

December-17-13 9:17:21 AM

110168

Page 1

Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Lid Assembly (350)
 Start Date: 12/17/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-12-18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4018	D

100 Weld per dwg A/R S.S. rod Batch: 4128823 0.00
 Large Fab
100
 Large Fab
 Memo 0.00
 1- assemble ribs , weld as per dwg D4018 using DT9607B
 2- weld hinge (3) and Mounting brackets as per dwg D4018
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

DAS
43
9-89
14-7-5
14-5-4

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC
 Quality Control
 Memo 0.00

DAS
24
9-89
14-7-9

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Item ID: D4018-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Short Basket Lid Assembly (350)

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1*	14.7.9		DAS 24 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo 11/10/13	0.00							DAS 34 9-89
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 1:25 Oven Temperature: 300° Finish Time: 1:55								
140	Wing Walk as per dwg QSI005 4.4 Batch 1112939	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

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 Item Name: Short Basket Lid Assembly (350)
 Start Date: 12/17/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 2/3 0.00 14/1/10				1			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/o</u> Memo	0.00 0.00 D-1032-041 / B110364				1x	f	20	11/67/10
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ	14-07-14		

(H) 14-7-10

Picklist Print

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Work Order ID: 110168

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15
verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D
as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-
624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1 Rib		Manufactured	No			100	Each	2.0000	2	2		DAS 43 9-89	14.7.5
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		2							
				107022		2							
D4018-3 Rib		Manufactured	No			100	Each	4.0000	2	2		DAS 43 9-89	14.7.5
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		4							
				107758		4							
D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	43.0000	3	3		DAS 43 9-89	14.7.5
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		43							
				103029		23							
				106882		20							
D4018-5 Rib		Manufactured	No			100	Each	24.0000	6	6		DAS 43 9-89	14.7.5
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA004		24							
				100347		3							
				104988		18							
				106726		3							

Picklist Print

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Work Order ID: 110168

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 2.0000

² B 114988 → 2x ² DAS 43 9-89 14-7-5

Location	Loc Qty	Loc Code
WA004	2	
107509	1	
108589	1	

D2581 Manufactured No
Mounting Bracket

100 Each 264.0000

² B 117900 → 2x ² DAS 43 9-89 14-7-5

Location	Loc Qty	Loc Code
WA004	264	
102265	94	
103683	98	
105886	48	
107768	24	

D4020-7 Manufactured No
Mesh (350 Basket Short, Lid)

100 Each 0.0000

¹ B 116916 ¹ DAS 43 9-89 14-7-5

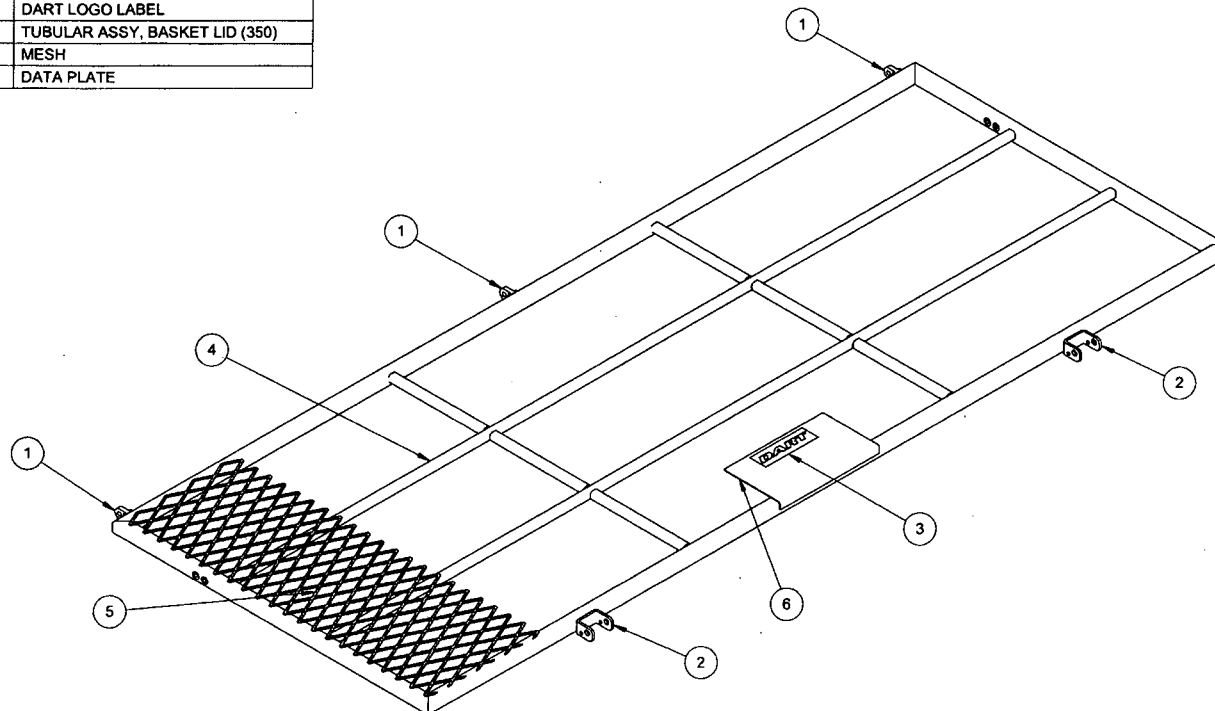
D4021-3 Manufactured No
Data Plate

100 Each 27.0000

¹ B 116081 ¹ DAS 43 9-89 14-7-5

Location	Loc Qty	Loc Code
WA004	27	
101346	27	

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

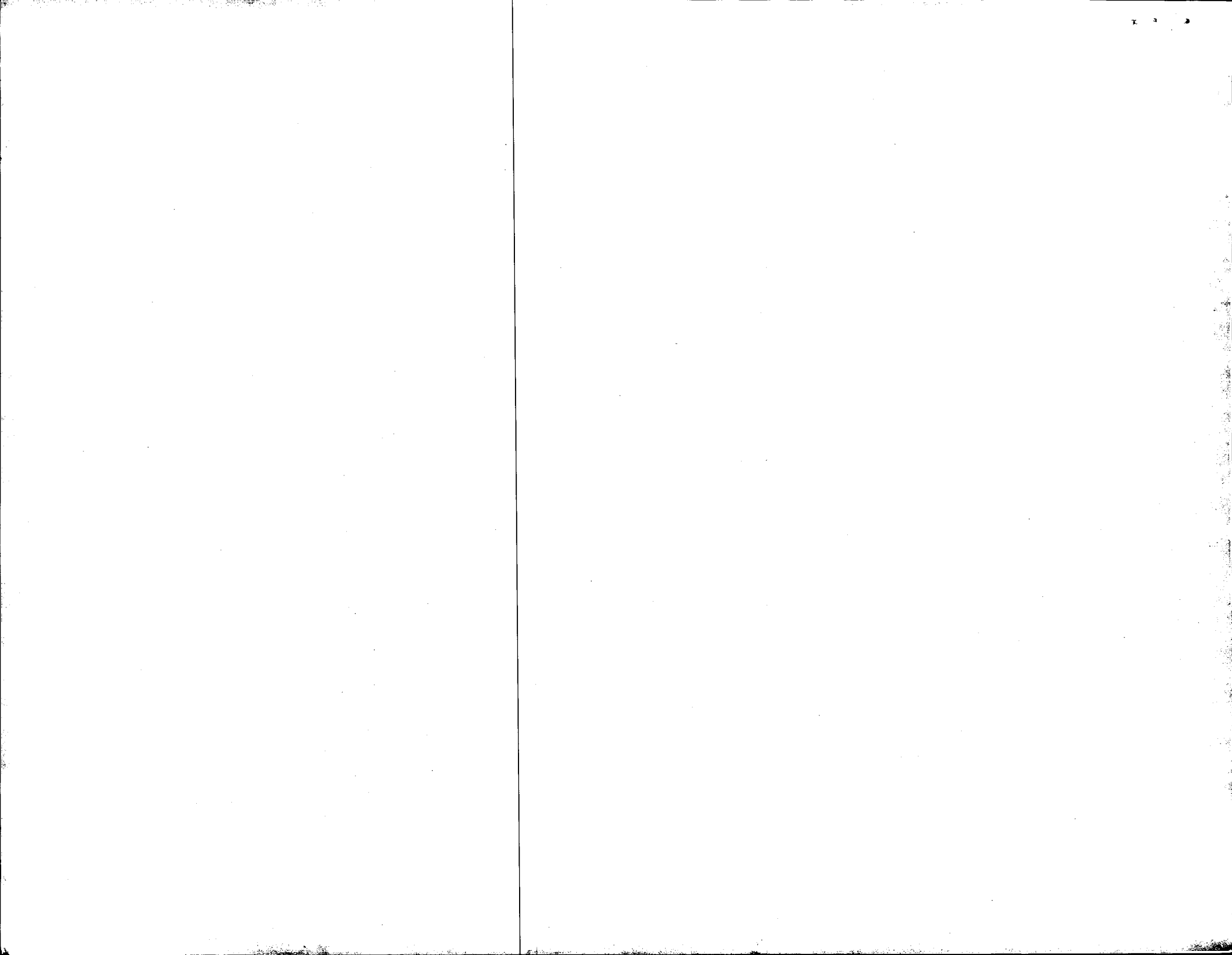


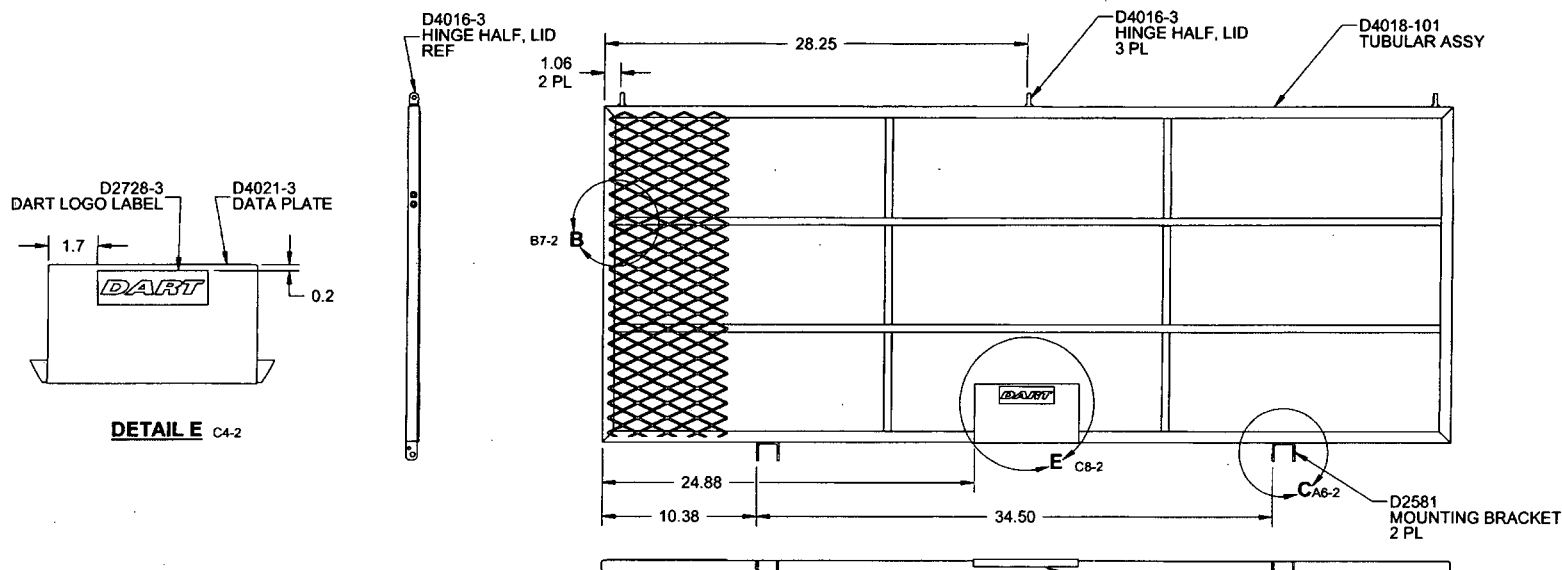
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

110168 MLC
13-12-18

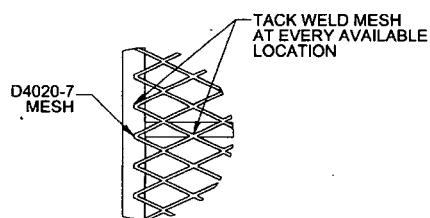
RELEASED
2013-08-16

D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	4P	DRAWING NO.	REV. D
MFG. APPR.	10/1	D4018	SHEET 1 OF 4
APPROVED	10/1	TITLE	SCALE
DE APPR.	10/1	SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

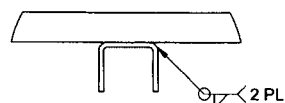




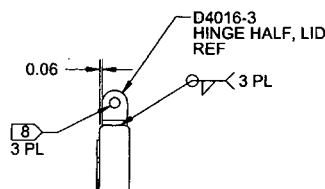
DETAIL E C4-2



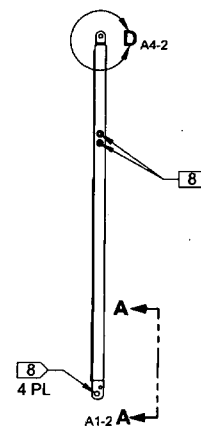
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

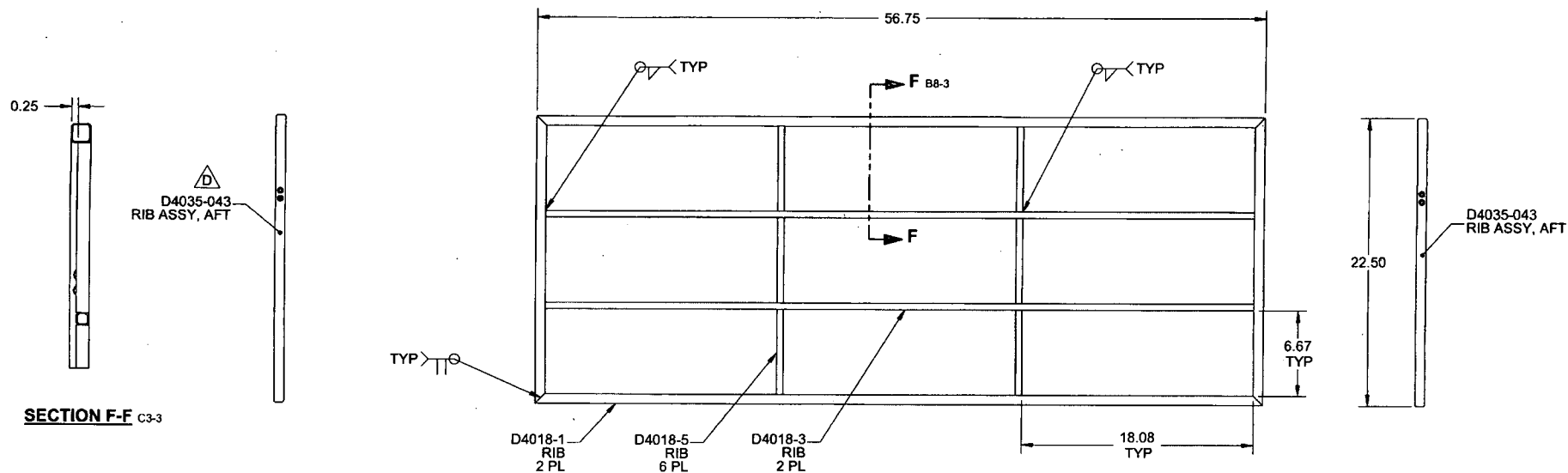
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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RELEASED
2013-08-16

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



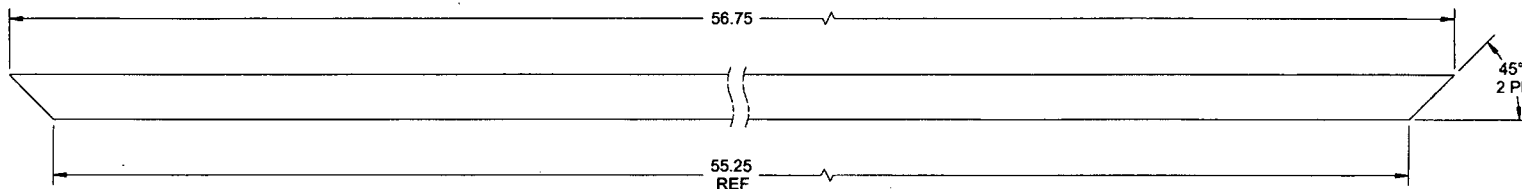
SECTION F-F C3-3

8 D4018-101 TUBULAR ASSY, BASKET LID (350)

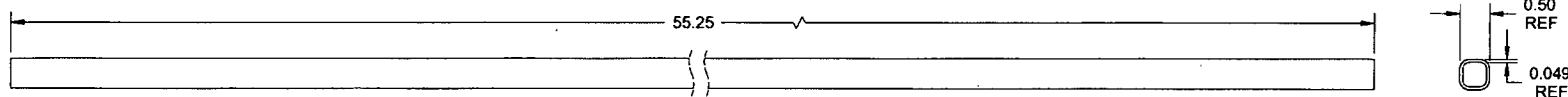
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2013-08-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

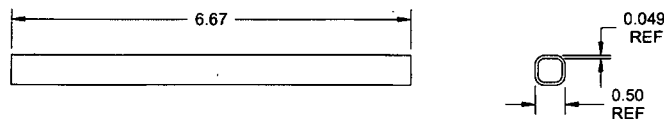
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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